

Date: Tuesday, 19/08/2008 4:04:11 PM
User: Julie Lecocq

Process Sheet

| | |
|--|---|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : AFT CAP |
| Job Number : 41435 | |
| Estimate Number : 10312 | |
| P.O. Number : | Part Number : D2646 |
| This Issue : 19/08/2008 S.O. No. : | Drawing Number : D2646 REV C |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : PURCHASED PARTS | Drawing Revision : C |
| Previous Run : 37755 | Material : |
| Written By : | Due Date : 20/09/2008 Qty: 50 Um: Each |
| Checked & Approved By : <u>NO 08.8.19</u> | |
| Comment : Est: G 05.08.22 Hole size revised in Step 5 KJ/JLM Est Rev:H Changed Inserts 07-02-19 JLM est rev I changed inserts 07.06.11 EC | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---|-----------------------|-------------------------------|
| 1.0 | PG | PURCHASING |
| | | |
| Comment: PURCHASING Issue P/O: <u>7000</u> 1-Spin as per Dwg D2646 2-Material release note required <u>C208/08/21</u> (50) | | |
| 2.0 | D2646P | Aft Cap |
| | | |
| Comment: Qty: 1.0000 Each(s)/Unit Total : 50.0000 Each(s) AFT CAP | | |
| 3.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
| | | |
| Comment: PACKAGING RESOURCE #1 Receive & Inspect for Transit Damage Ensure Material Release Note is attached <u>P 8/21</u> (50) | | |
| 4.0 | QC6 | DIMENSIONAL CHECK |
| | | |
| Comment: DIMENSIONAL CHECK Inspect dimensions as per Dwg D2646 <u>08/08/28</u> (50) <u>counters</u> | | |
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
| | | |
| Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Drill using DT8026 as per Dwg D2646. <u>08/09/02</u> (50) | | |

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 19/08/2008 4:04:11 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CAP

Job Number: 41435

Part Number: D2646

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Open holes to .297 as per Dwg D2646.

3-Deburr

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP



7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

8.0

POWDER COATING

POWDER COATING



M108523



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:45
320 OF
2:15

M-H 08/09/12

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

ALS71032130

Insert



Comment: Qty.: 2.0000 Each(s)/Unit Total: 100.0000 Each(s)

INSERT

Batch:

M105819

M-H

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install inserts as per Dwg D2646

M-H 08/09/13

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

080915 50

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 19/08/2008 4:04:12 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CAP

Job Number: 41435

Part Number: D2646

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



50x

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FP-7

mf

08/09/15

14.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/15

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-09-15

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

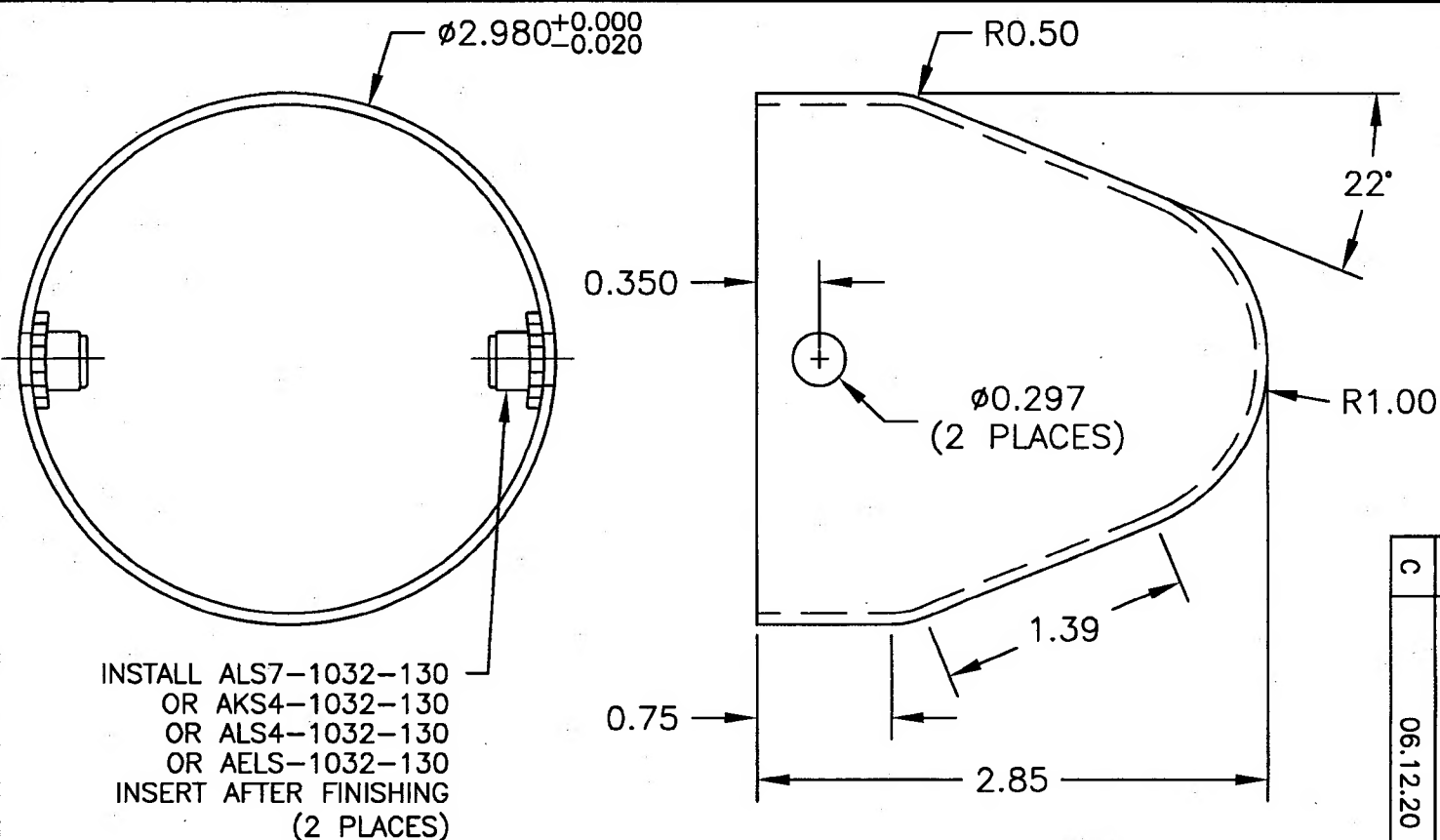
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

DART

| DESIGN | DS | DRAWN BY | PH | DART AEROSPACE USA, INC. |
|---------|----------|------------------------------|---------|--------------------------|
| CHECKED | | APPROVED | | PORT HADLOCK, WA |
| DATE | 06.12.20 | TITLE | AFT CAP | REV. C |
| | | DRAWING NO. | D2646 | SHEET 1 OF 1 |
| A | 97.03.25 | NEW ISSUE | | SCALE |
| B | 05.04.01 | CHANGE TO CLOSED INSERTS | | |
| C | 06.12.20 | CHANGE TO OPEN ENDED INSERTS | | |

**D2646 AFT CAP**

- 1) MATERIAL: ALUMINUM 1100-0 0.063 THICK (QQ-A-250/1)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44435

RELEASED
07.02.12



Sieg's Manufacturing Ltd.
Metal Fabricating

6236 - 205 STREET, LANGLEY, B.C. V2Y 1N7
TELEPHONE: (604) 530-7455 • Fax: (604) 530-7490

Packing Slip

Packing Slip No.:

35672

Date:

08/27/2008

Page:

1

| | |
|---|--|
| Sold to: DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7 | Ship to: DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7 |
| Order No.: 7000 | Sold By: KAULBARS, KALE |
| Shipped By: fedex | Ship Date: 08/27/2008 |
| Tracking No.: | |

| Item No | Unit | Description | Quantity |
|----------|------|---------------------------------------|----------|
| B2646P | EACH | AFT GEAR REV.C <i>08/30/08</i> | 50 |
| Comment: | | | |



Sleg Manufacturing Ltd.

Turning and Fabricating

6236 - 205 STREET, LANGLEY, B.C. V2Y 1N7
TELEPHONE: (604) 530-7455 • FAX: (604) 530-7490

INSPECTION REPORT

Date: Aug. 27/08
Customer: Dart Aerospace
Packing Slip: 35672

| Part#: | Qty | Material | Check holes | Debur edges | Insp. By |
|---------------|-----|-------------|----------------|----------------|--------------------|
| B41435 rev. C | 10 | 14G 1100 | N/A | ✓ | <i>[Signature]</i> |
| | | | | | |
| | | | | | |
| | | | | | |

Notes:

08/08/28

Material Certification Attached: Yes.

W. H. KERRY



ALCOA INHIL PRODUCTS
1480 Manheim Pike
Cancaster Pa 17601

Certification of Test Results

P/N 970200

PO 38C880

SOLD TO

SHIP TO

CERT NO 1000675396
DATE 4/23/2007
SKID NO 661031
SKID WGT 9.885
PAGE 1 OF 1

| | | | | | | |
|----------|--------|---------|----------|--------|--------|---------------------------|
| ORDER NO | LGS947 | PO NO | 43-62756 | | | MILL FINISH |
| ITEM NO | 1 | PART NO | | | | NON ANODIZE QUALITY |
| ALLOY | 1100 | TEMPER | O | FORM | COIL | OUT: STANDARD MILL FINISH |
| GAUGE | .06300 | WIDTH | 48.0000 | LENGTH | 0.0000 | IN: STANDARD MILL FINISH |
| | | | | | | NOT EMBOSSED |

LOT: 114171 COIL: B01 DROP: 07T0187

| INGOT | SI | FE | CU | MN | MG | CR | NI | ZN | TI |
|---------|------|------|------|------|------|------|------|------|------|
| U718321 | 0.12 | 0.49 | 0.12 | 0.02 | 0.01 | 0.01 | 0.01 | 0.01 | 0.01 |

HEAD ULTIMATE STRENGTH 13.1 KSI
TAIL ULTIMATE STRENGTH 13.0 KSI
HEAD YIELD STRENGTH (OFFSET = .2%) 5.5 KSI
TAIL YIELD STRENGTH (OFFSET = .2%) 5.3 KSI
HEAD ELONGATION (G.L. = 2 IN) 32 %
TAIL ELONGATION (G.L. = 2 IN) 31.5 %

* AS REPORTED BY SUPPLIER
MECHANICAL PROPERTIES ACCORDING TO ASTM B-557-06

MECHANICAL AND CHEMICAL PROPERTIES MEET THE REQUIREMENTS OF:

ASME SB209 1100 C, AMS 4001H 1100 O,
ASTM B209-06 1100 O, AMS-QQ-A-250/1 1100 O

PAX CERTS: 714-736-4640

** END OF CERTIFICATION **

We hereby certify that, unless otherwise indicated, the material covered by this report has been manufactured, inspected, and tested in accordance with, and has been found to meet, the applicable requirements described herein, including any specifications forming a part of the description and that samples representative of the material meet the composition. Also, note that mercury is not a normal contaminant in aluminum alloys and neither it nor any of its compounds are used in the manufacture of our product. Certification of test results shall not be reproduced except in full.

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Authorized By:

JEFF KREADY, LAB SUPERVISOR

Sold to: COPPER & BRASS SALES PO: 38C880 Part: Order No.: 376276

TR clerk signature: *C. J. [Signature]*

